

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 13.02.22	Job No.:	ADR Yes/No: Y	ADR Date:	ECN #: 13- 534
Product No.: D119-646		Created By: DB	Approved By: <i>MP</i>	
Product Name: A119 SKIDTUBES		Checked By: <i>DB</i>		

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations			
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.		CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing		RM/CA	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/DS	
Marketing	Y	HM	

Reason for Change: Cap assembly hardware interferes with the installation of the Agusta Ground handling Wheel Kit

Documents Affected: D3887 to Rev C, D3905 to Rev C, DSI-9594 to Rev B,

PAPERWORK UPDATE ☐ **PARTS MUST COMPLY** ☒ **PREVIOUS PARTS SATISFACTORY** ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	DB		13.02.22
5	Update Master Document List (MDL)	Y	DB		13.02.22
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		
11	Update Product Specification Files	Y	KJ	DSI 9594	13.03.19 <i>DB</i>
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		13.03.19 <i>DB</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		13.03.19 <i>DB</i>
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	KJ		
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		13.03.19 <i>DB</i>
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		13.03.19 <i>DB</i>
24	Manufacturing Licensing Agreement Update				

Description / Action:
Current assembly hardware for the FWD Skidtube Cap (AN3C5A Bolt, washers) interferes with the installation of the Agusta Ground handling Wheel Kit. Replacing the hardware with a #10-32 Flat Head Screw (countersunk) eliminates the interference.
Incorporate DEO D3905-B-1 into drawings D3887 and D3905 (installation of D2579 Cross Bolt Spacers)
D119-646-011/-012/-013/-014/-111/-112/-113/-114/-041/-043/-141/-143/-241/-243 to CHG 003 (was CHG 002)
D119-646-211/-212/-213/-214 to CHG 004 (was CHG 003)
DSI 9594-011 to Chg 002 (was 001)

2d cap updated

ECN Verified & Complete: _____ Date: _____

Linda Lacelle

From: Mike Petsche
Sent: March-06-13 10:27 AM
To: Linda Lacelle; David Shepherd
Cc: Eric Downing
Subject: RE: 119 skids

Yeah that's pretty much the gist of it. The DSI had been for A-W to do the mod for the aircraft that is here at the show. But for any stock/WIP you have, do exactly what you just said.

Dave (Bain) has updated the dwgs. An ECN should not be terribly far off. (I'm checking with him now to see where it is)

From: Linda Lacelle
Sent: Wednesday, March 06, 2013 7:36 AM
To: David Shepherd
Cc: Mike Petsche; Eric Downing
Subject: RE: 119 skids

Thx David. I'm a bit confused though, this DSI is for the customer when in the field correct? All we have to do is countersink the holes for the cap, re-alodine, touch up, replace cap with screw, correct?
LL

From: David Shepherd
Sent: March-05-13 2:32 AM
To: Mike Petsche; Linda Lacelle
Subject: RE: 119 skids

Linda,

I am good with modifying the front end of the 119 skidtubes to the attached DSI.

Regards,
David

From: Mike Petsche
Sent: March-04-13 10:17 AM
To: Linda Lacelle; David Shepherd
Subject: FW: 119 skids

fyi

From: David Bain
Sent: Monday, March 04, 2013 12:06 PM
To: Mike Petsche
Subject: RE: 119 skids

Mike,

ECN B-534

new work info

- 98121 > 91561
- 98122 > 91560

- 211 x 2 sth

wp > 93010
93011
93012
93013

94837

93014

- 212 x 3 sth

wp > 91627

93016
93017
93018

93019

new work info
98123 > 91615
98124 > 91626
98125
98126 > 91625

- 211 98131 >
91578

David came back with some changes that were incorporated into the drawings on Friday. I sent back two final minor changes this morning for David to sign off. The ECN is being written today so we will try to have this ready by tomorrow.

DB

From: Mike Petsche
Sent: Monday, March 04, 2013 11:28 AM
To: David Bain
Subject: FW: 119 skids
Importance: High

FYI...

From: Linda Lacelle
Sent: Monday, March 04, 2013 7:23 AM
To: Mike Petsche; David Shepherd
Subject: 119 skids
Importance: High

Hi all,

Does anyone know when we will be receiving the ecn for the 119 skids? We have 5 sets to ship on March 22nd, and we need to get started on the rework asap.

Thx

Linda

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with $\varnothing 0.500"$ (12.7 mm drill), and countersunk to $\varnothing 0.650 \times 100^\circ$, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to $\varnothing 0.385 \times 100^\circ$.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the $\varnothing 0.500$ holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
- 2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER
4	MS24694-C52	SCREW

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

B	ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS	DB	13.02.20
A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD GROUND HANDLING SPACER KIT	NTS
DATE	13.02.20	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC.	
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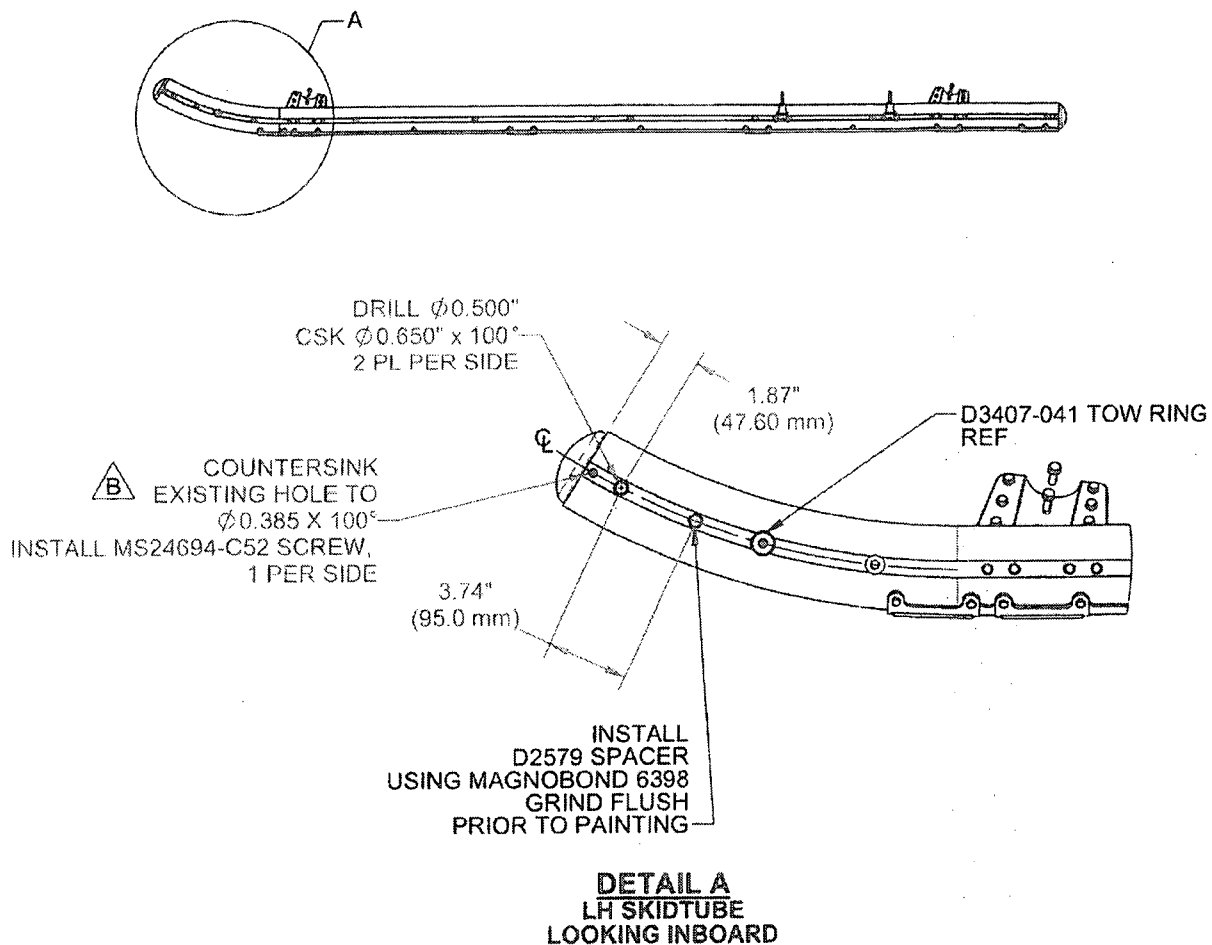


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

DESIGN		RF	DART AEROSPACE USA, INC	
DRAWN		DB	KENT, WA	
CHECKED		MB	DRAWING NO.	REV. B
MFG. APPR.		N/A	DSI 9594	SHEET 2 OF 2
APPROVED		<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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